

Date: Tuesday, 10/24/2006 12:58:47 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	: 29148A			Part Number	: D32241		
Estimate Number	: 10300			Drawing Number	: D3224 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/24/2006 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 10/31/2006 Qty: 8 Um: Each		
Previous Run	: 24329						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 05-11-06 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: _____ Email or Ship DXF file to vendor Laser Cut D3224-1 flat pattern per Dwg D3224 Possible Supplier: GFI Material release note is required
2.0	D3224B	Frame
		Comment: Qty.: 1.0000 U(s)/Unit Total : 8.0000 U(s) Frame
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FRAME

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Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29148A
Description: Frame	Part Number:	D3224-1
Inspection Dwg: D3224	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

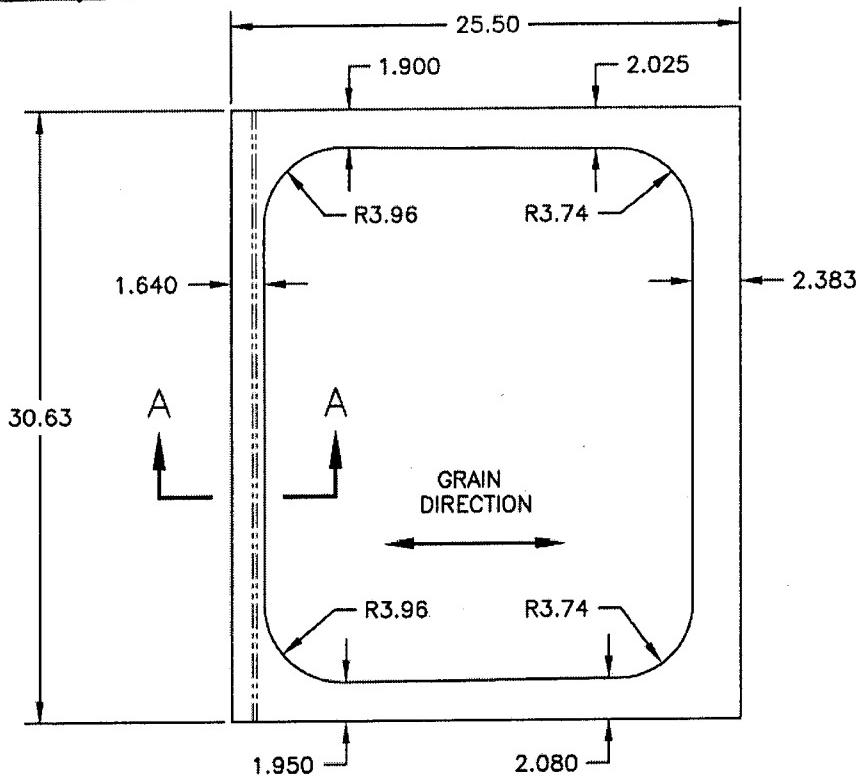
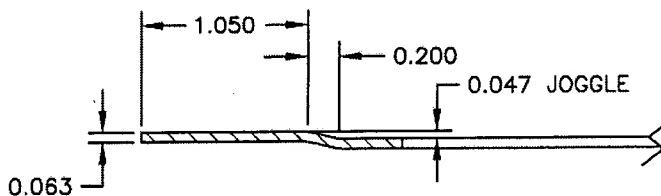
Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	P/O D412-709-011	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3224	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.21		FRAME	NTS
A	03.10.21	NEW ISSUE	

RELEASED

04.02.03

**D3224-1****SECTION A-A**

SCALE 8:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29148A

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED